

TAPPING TS CHART

MODEL ENGINEERS' WORKSHOP

FRACTION, GAUGE & LETTER DRILL SIZES			TAPPING DRILL		THREAD		FRACTION, GAUGE & LETTER DRILL SIZES			TAPPING DRILL		THREAD	
FRACTION (in.)	OLD DRILL GAUGE	DEC. EQUIV. (in.)	BRITISH STANDARD (International) SERIES		UNF UNC	BA BSW BSF	FRACTION (in.)	OLD DRILL GAUGE	DEC. EQUIV. (in.)	BRITISH STANDARD (International) SERIES		UNF UNC	BA BSW BSF
			New Size (mm)	Dec. Equiv. (in.)						New Size (mm)	Dec. Equiv. (in.)		
	M	.2950	7.50	.2953					19.25	.7579			7/8 BSW
19/64		.2969					49/64	.7656		.7656			7/8 -9
	N	.3020	7.70	.3031			25/32	.7812		.7812			7/8 BSF
5/16		.3125		.3125		3/8 BSW	51/64	.7969					
	O	.3160	8.00	.3150	3/8 -16			.8040		.8040			7/8 -14
	P	.3230	8.20	.3228			13/16	.8125					
			8.25	.3248		3/8 BSF	53/64	.8281					
21/64		.3281					27/32	.8438					
	Q	.3320	8.40	.3307			55/64	.8594					
			8.50	.3346	3/8 -24				22.00	.8661			1 BSW
	R	.3390	8.60	.3386			7/8	.8750					
11/32		.3438							22.25	.8760			1 -8
	S	.3480	8.80	.3465			57/64	.8906					
	T	.3580	9.10	.3583					22.75	.8957			1 BSF
23/64		.3594					29/32	.9062					
			9.25	.3642		7/16 BSW			23.25	.9154			1 -12
	U	.3680	9.30	.3661			59/64	.9219					
			9.40	.3701	7/16 -14		15/16	.9375					
3/8		.3750					61/64	.9531					
	V	.3770	3/8	.3750			31/32	.9688					
			9.70	.3819		7/16 BSF			24.75	.9744			1 1/8 BSW
	W	.3860	9.80	.3858			63/64	.9844		.9844			1 1/8 -7
			9.90	.3898	7/16 -20		1	1.0000					
25/64		.3906							25.50	1.0039			1 1/8 BSF
	X	.3970	10.10	.3976					26.50	1.0433			1 1/8 -12
	Y	.4040	10.30	.4055			1 3/32	1.0938		1.0938			1 1/4 BSW
13/32		.4062					1 7/64	1.1094		1.1094			1 1/4 -7
	Z	.4130	10.50	.4134		1/2 BSW	1 1/8	1.1250					
27/64		.4219							28.75	1.1319			1 1/4 BSF
			10.80	.4252	1/2 -13				29.50	1.1614			1 1/4 -12
7/16		.4375		.4375		1/2 BSF			30.75	1.2106			1 3/8 -6
		.4488	11.40	.4488	1/2 -20				31.50	1.2402			1 3/8 BSF
29/64		.4531					1 1/4	1.2500					
15/32		.4688						1.2900		1.2900			1 3/8 -12
		.4764	12.10	.4764		9/16 BSW			33.50	1.3189			1 1/2 BSW
		.4823	12.25	.4823	9/16 -12		1 21/64	1.3281		1.3281			1 1/2 -6
31/64		.4844					1 23/64	1.3594		1.3594			1 1/2 BSF
1/2		.5000		.5000		9/16 BSF	1 3/8	1.3750					
			12.90	.5079	9/16 -18				36.00	1.4173			1 1/2 -12
33/64		.5156					1 1/2	1.5000					
17/32		.5312							39.00	1.5354			1 3/4 BSW
			13.50	.5315	5/8 -11	5/8 BSW	1 35/64	1.5469		1.5469			1 3/4 -5
35/64		.5469					1 5/8	1.6250					
			14.00	.5512		5/8 BSF	1 3/4	1.7500					
9/16		.5625							44.50	1.7520			2 BSW
			14.50	.5709	5/8 -18		1 25/32	1.7812		1.7812			2 -4.5
37/64		.5781											
19/32		.5938											
39/64		.6094											
5/8		.6250											
41/64		.6406		.6406		3/4 BSW							
			16.50	.6496	3/4 -10								
21/32		.6562											
			16.75	.6594		3/4 BSF							
43/64		.6719											
11/16		.6875		.6875	3/4 -16								
45/64		.7031											
23/32		.7188											
47/64		.7344											
3/4		.7500											

BRITISH STANDARD PIPE THREADS

THREAD	TAPPING DRILL (mm)	DECIMAL EQUIVALENT (in.)	THREAD	TAPPING DRILL (mm)	DECIMAL EQUIVALENT (in.)
1/8 -28	8.75	.3445	7/8 -14	28.25	1.1122
1/4 -19	11.80	.4646	1-11	30.75	1.2106
3/8 -19	15.25	.6004	1 1/4 -11	39.50	1.5551
1/2 -14		3/4 .7500	1 1/2 -11		1 25/32 1.7812
5/8 -14		53/64 .8281	1 3/4 -11	51.00	2.0079
3/4 -14	24.50	.9646	2 -11		2 1/4 2.2500